

Date: Monday, 09/02/2009 11:21:01 AM
 User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D350-636-013
 Job Number : 45614
 Estimate Number : 10804
 P.O. Number :
 This Issue : 09/02/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : SKIDTUBES
 Previous Run : 00015
 Written By :
 Checked & Approved By : JUD 09.02.09
 Comment :

Part Number : D350636013
 Drawing Number : R09-012
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 16/02/2009 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D350636013 Skidtube LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Skidtube LH
 Original B39347 @ CHG004

JUD 09-02-09 (01)



2.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

- Disassemble the tube, and do not discard any hardware. Keep the hardware in a box, and identify it with the part and batch #, so tracability is kept. Keep the original kit as well all together.

- Pressure wash, and remove the LPS inside and outside of the tube.

- Scuff the entire surface using 320 grit, and remove any surface defects.

AWM 9-4-16

JUD 09-04-02 (XU)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JUD 09/04/08 (X0)

4.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
 Re-powdercoat per QSI 005

Start time: 9:00

Temp: 320°

Finish time: 9:30

M. 110939

m 109996

Pressure wash MD/ FL.

start time: 1:10

Temp.: 320°

Finish time: 1:40

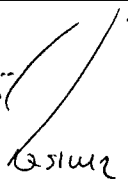
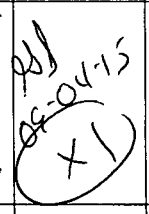

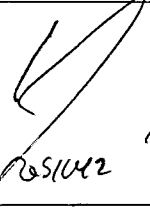
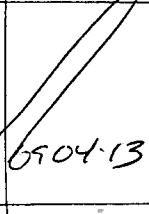
BR 09-04-13 (01)

PTC 09/05/04 (01)
FL 09/05/04 (01)

Powder coat the wearpads Grey as necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-636-013 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/06/01
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>45614</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-04-13	4.0	Upon re-powder coating, the Final Finish was full of Spider web like marks & wetting on the surface. Grounding was not 100%. R.C. process.		Strip entire tube & scuff smooth. Alcoholize the surface by hand after scuffing * Do NOT De-oxidize * re-powder coat per spec				

NOTE: Date & initial all entries

Date: Monday, 09/02/2009 11:21:01 AM
User: Julie Dawson

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D350-636-013

Job Number: 45614

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/05/04 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Re-assemble the tube using the original hardware.

LPS the inside of the tube. M

09-05-04 (X)

PTO

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*** Ensure the original kit is identified and with the tube for packaging***

09/05/05 @

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

New labels, decals, and paperwork are required.

Ensure the original kit is being packaged with the correct tube.

CHG 004

09/05/05

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/05/12 @

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package per PPP, and return to stock.

Location:

09/05/12 (1)

11.0

QC21

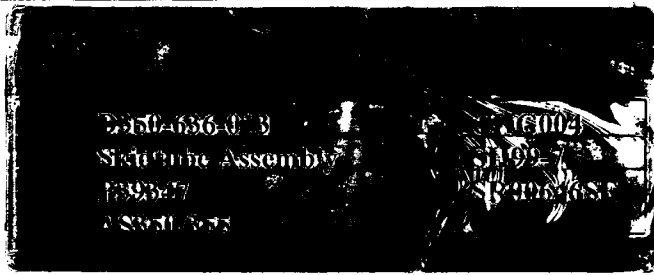
FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/01

Job Completion



05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-05-01	6.1	Scrap "insert" NAS1330C3KB-166/M 103279 then replace with new "inserts" NAS1330C3KB-166 / M 111258	JH	09-05-01	42		S 09/05/01
09-05-01	6.1	Scrap the Following Parts:					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 8:28:53 AM
 User: Melanie Fauteux

Process Sheet

DAR

6.0

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 45614
 Estimate Number : 10804
 P.O. Number :
 This Issue : 11/05/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 09/02/2009 Type : SKIDTUBES
 Previous Run : 00015
 Written By :
 Checked & Approved By : mf 09-05-11
 Comment :

Drawing Name : D350-636-013

Part Number : D350636013

Drawing Number : R09-012

Project Number :

Drawing Revision :

Material :

Due Date : 16/02/2009

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade, 350 Skidtube

45322

11.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

M111427

12.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

NUT

M111427

13.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

BOLT

M110342

APPLY ANISENZE M110658

14.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

M108964

APPLY ANISENZE M110658
 6/9/09

THIS D

Date: Wednesday, 01/04/2009 1:08:10 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 39347	Customer	: Dart Aerospace Ltd.
Estimate Number	: 10804	DWG Name	: D350-636-013
Purchase Order #	:	Part Number	: D350636013
Complete Date	: 05/06/2008 11:59:59	DWG Number	: R08-041
Rev. :			

DUE DATE	ORDERED	DELIVERED
27/05/2008	1	1

1.0 D350636013-Skidtube LH INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
05/06/2008	FAUT01: Fauteux, Melanie	D350636013	1.000		\$2113.81		Lot # B32528 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$2113.81							

3.0 HAND FINISHING1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
04/06/2008	LAUG01: Laughren, Gary	Run	0.000	2.21	\$34.37	2.21	83.52
Subtotal: QTD: 0 CTD: 0 2.21 \$117.89							

8.0 HAND FINISHING1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
04/06/2008	LAUG01: Laughren, Gary	Run	1.000	1.01	\$15.71	1.03	38.93
Subtotal: QTD: 1 CTD: 0 1.01 \$54.64							

9.0 D37941-Gasket INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
04/06/2008	LAUG01: Laughren, Gary	D37941	1.000		\$3.80		Lot # 39279 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$3.80							

10.0 D37931-Wearshoe INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
04/06/2008	LAUG01: Laughren, Gary	D37931	1.000		\$26.29		Lot # 39277 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$26.29							

11.0 D37911-Wearplate INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
04/06/2008	LAUG01: Laughren, Gary	D37911	1.000		\$25.39		Lot # 39276 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$25.39							

12.0 D37943-Gasket INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
04/06/2008	LAUG01: Laughren, Gary	D37943	1.000		\$2.37		Lot # 39361 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$2.37							

13.0 D37933-Wearshoe INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
04/06/2008	LAUG01: Laughren, Gary	D37933	1.000		\$21.10		Lot # 39479 Qty. 1
Subtotal: QTD: 0 CTD: 1 \$21.10							

14.0 D36721-Phenolic Washer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
04/06/2008	LAUG01: Laughren, Gary	D36721	8.000		\$2.16		Lot # 39275 Qty. 8
Subtotal: QTD: 0 CTD: 8 \$2.16							

REFERENCE ONLY

Date: Wednesday, 01/04/2009 1:08:10 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 39347	Customer	: Dart Aerospace Ltd.
Estimate Number	: 10804	DWG Name	: D350-636-013
Purchase Order #	:	Part Number	: D350636013
Complete Date	: 05/06/2008 11:59:59	DWG Number	: R08-041
		Rev.	:

15.0 AN526C1032R10-Screw INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
04/06/2008	LAUG01: Laughren, Gary	AN526C1032R10	4.000		\$0.52	Lot # 108062 Qty. 4
Subtotal:		QTD: 0 CTD: 4			\$0.52	

16.0 AN526C1032R18-Screw INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
04/06/2008	LAUG01: Laughren, Gary	AN526C1032R18	4.000		\$4.49	Lot # 108079 Qty. 4
Subtotal:		QTD: 0 CTD: 4			\$4.49	

17.0 D35371-Wearpad INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
06/06/2008	FAUT01: Fauteux, Melanie	D35371	2.000		\$54.30	Lot # 37292 Qty. 1 Lot # 38254 Qty. 1
Subtotal:		QTD: 0 CTD: 2			\$54.30	

18.0 D353525-Wearshoe INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
06/06/2008	FAUT01: Fauteux, Melanie	D353525	1.000		\$19.32	Lot # 38867 Qty. 1
Subtotal:		QTD: 0 CTD: 1			\$19.32	

19.0 D353625-Gasket INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
06/06/2008	FAUT01: Fauteux, Melanie	D353625	1.000		\$3.39	Lot # 38565 Qty. 1
Subtotal:		QTD: 0 CTD: 1			\$3.39	

20.0 MS21083C8-NUT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
06/06/2008	FAUT01: Fauteux, Melanie	MS21083C8	1.000		\$1.29	Lot # 107939 Qty. 1
Subtotal:		QTD: 0 CTD: 1			\$1.29	

		TIME	COST	
	Machine Time:	3.24	\$122.45	
	Labor:	3.22	\$50.08	
	Sub-contract (external Op.):		\$0.00	
	INVENTORY ITEM:		\$2278.23	
	SUB-COMPONENT (SUB-JOB):		\$0.00	
Total:			\$2450.76	
COST PER UNIT:			\$2450.76	

Date: Wednesday, 08/04/2009 7:50:51 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 32528	Customer	: Dart Helicopters Services
Estimate Number	: 10266	DWG Name	: 350 SKIDTUBE ASSEMBLY LH
Purchase Order #	:	Part Number	: D350636013
Complete Date	: 09/08/2007 12:48:03	DWG Number	: D2750 UNDER REVIEW
		Rev.	: D

DUE DATE		ORDERED	DELIVERED	
20/06/2007	1		1	

2.0 D26003BENT-Extrusion Bent

INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
04/06/2007	RAIN01: Rainey, Jamie	D26003BENT	1.000		\$33.04	Lot # 30666 Qty. 1
Subtotal:			QTD: 0	CTD: 1	\$33.04	

3.0 D2744-Cap

INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
09/08/2007	LAVO01: Lavoie, Chantal	D2744	1.000		\$4.85	Lot # 29784 Qty. 1
Subtotal:			QTD: 1	CTD: 0	\$4.85	

4.0 SKIDTUBES 1

Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
04/06/2007	RAIN01: Rainey, Jamie	Run	0.000	0.00	\$0.00	0.19	3.94	
04/06/2007	RAIN01: Rainey, Jamie	Run	1.000	0.19	\$3.13	0.00	0.00	PROVR
05/06/2007	RAIN01: Rainey, Jamie	Run	0.000	0.00	\$0.00	1.46	30.28	
05/06/2007	RAIN01: Rainey, Jamie	Run	1.000	1.46	\$24.03	0.00	0.00	PROVR
07/06/2007	ELLI01: Elliott, Barclay	Run	0.000	0.50	\$8.23	0.50	10.37	
Subtotal:			QTD: 2	CTD: 0	2.15	\$79.98		

7.0 HAND FINISHING1

Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost	
07/06/2007	MCPH01: McPherson, Patrick	Run	0.000	0.75	\$12.35	0.75	23.36	
Subtotal:			QTD: 0	CTD: 0	0.75	\$36.30		

9.0 D2739-350 I Beam

INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
14/06/2007	RAIN01: Rainey, Jamie	D2739	1.000		\$41.34	Lot # 32582 Qty. 1
Subtotal:			QTD: 0	CTD: 1	\$41.34	

10.0 D34901-Cross Bolt Spacer

INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
20/06/2007	ELLI01: Elliott, Barclay	D34901	4.000		\$12.78	Lot # 32045 Qty. 4
Subtotal:			QTD: 0	CTD: 4	\$12.78	

11.0 D34905-Cross Bolt Spacer

INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
20/06/2007	ELLI01: Elliott, Barclay	D34905	4.000		\$16.47	Lot # 32597 Qty. 4
Subtotal:			QTD: 0	CTD: 4	\$16.47	

12.0 D2743-Crossbolt Spacer

INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
20/06/2007	ELLI01: Elliott, Barclay	D2743	8.000		\$26.71	Lot # 29011 Qty. 8
Subtotal:			QTD: 0	CTD: 8	\$26.71	

Date: Wednesday, 08/04/2009 7:50:51 AM
 User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 32528	Customer	: Dart Helicopters Services
Estimate Number	: 10266	DWG Name	: 350 SKIDTUBE ASSEMBLY LH
Purchase Order #	:	Part Number	: D350636013
Complete Date	: 09/08/2007 12:48:03	DWG Number	: D2750 UNDER REVIEW
		Rev.	: D

13.0 SKIDTUBES 1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
14/06/2007	RAIN01: Rainey, Jamie	Run	1.000	0.73	\$12.02	0.73	15.15
19/06/2007	ELLI01: Elliott, Barclay	Run	0.000	1.58	\$26.01	1.58	32.77
20/06/2007	ELLI01: Elliott, Barclay	Run	311.000	1.02	\$16.79	1.02	21.16
20/06/2007	MCPH01: McPherson, Patrick	Run	1.000	1.89	\$31.11	1.89	39.20
21/06/2007	ELLI01: Elliott, Barclay	Run	0.000	0.56	\$9.22	0.56	11.62

Subtotal: QTD: 313 CTD: 0 5.78 \$215.05

16.0 POWDER COATING Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
01/08/2007	ROQU01: Roquebrune, Benoit	Run	1.000	0.66	\$9.08	1.28	34.14

Subtotal: QTD: 1 CTD: 0 0.66 \$43.22

18.0 NAS1330C3KB166-INSERT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
09/08/2007	LAVO01: Lavoie, Chantal	NAS1330C3KB166	42.000	\$117.60	Lot # 103279 Qty. 42

Subtotal: QTD: 42 CTD: 0 \$117.60

19.0 HAND FINISHING1 Internal Operation

DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
02/08/2007	TITL01: Titley, Ian	Run	1.000	0.87	\$14.32	0.87	27.78

Subtotal: QTD: 1 CTD: 0 0.87 \$42.10

21.0 D26483-Wearpad INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
03/08/2007	LAUG01: Laughren, Gary	D26483	5.000	\$47.50	Lot # 31695 Qty. 5

Subtotal: QTD: 0 CTD: 5 \$47.50

22.0 D265613-Wearplate INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
03/08/2007	LAUG01: Laughren, Gary	D265613	1.000	\$14.83	Lot # 30553 Qty. 1

Subtotal: QTD: 0 CTD: 1 \$14.83

23.0 D265635-Wearshoe INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
03/08/2007	LAUG01: Laughren, Gary	D265635	1.000	\$18.70	Lot # 30554 Qty. 1

Subtotal: QTD: 0 CTD: 1 \$18.70

24.0 D2746-Wearshoe INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty	COST	
03/08/2007	LAUG01: Laughren, Gary	D2746	1.000	\$15.69	Lot # 30141 Qty. 1

Subtotal: QTD: 0 CTD: 1 \$15.69

Date: Wednesday, 08/04/2009 7:50:52 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 32528	Customer	: Dart Helicopters Services
Estimate Number	: 10266	DWG Name	: 350 SKIDTUBE ASSEMBLY LH
Purchase Order #	:	Part Number	: D350636013
Complete Date	: 09/08/2007 12:48:03	DWG Number	: D2750 UNDER REVIEW
		Rev.	: D

25.0 D2745-Bushing INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
03/08/2007	LAUG01: Laughren, Gary	D2745	8.000		\$38.60	Lot # 31697 Qty. 8
Subtotal:		QTD:	0	CTD:	8	\$38.60

26.0 D3488041-Blade Fitting Assembly, LH INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
03/08/2007	LAUG01: Laughren, Gary	D3488041	1.000		\$278.66	Lot # 29432 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$278.66

27.0 D3492041-Plug Assembly INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
09/08/2007	LAVO01: Lavoie, Chantal	D3492041	8.000		\$0.00	Lot # 32598 Qty. 8
Subtotal:		QTD:	8	CTD:	0	\$0.00

28.0 D3492045-Plug Assembly INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
09/08/2007	LAVO01: Lavoie, Chantal	D3492045	8.000		\$45.46	Lot # 32599 Qty. 8
Subtotal:		QTD:	8	CTD:	0	\$45.46

29.0 AN3C5A-Bolt INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
03/08/2007	LAUG01: Laughren, Gary	AN3C5A	38.000		\$11.91	Lot # 104118 Qty. 38
Subtotal:		QTD:	0	CTD:	38	\$11.91

30.0 AN3C6A-BOLT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
03/08/2007	LAUG01: Laughren, Gary	AN3C6A	4.000		\$1.71	Lot # 103693 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$1.71

31.0 AN3C7A-BOLT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
03/08/2007	LAUG01: Laughren, Gary	AN3C7A	4.000		\$1.90	Lot # 103668 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$1.90

32.0 AN6C44A-BOLT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
03/08/2007	LAUG01: Laughren, Gary	AN6C44A	4.000		\$81.52	Lot # 103964 Qty. 4
Subtotal:		QTD:	0	CTD:	4	\$81.52

33.0 AN8C35A-BOLT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
03/08/2007	LAUG01: Laughren, Gary	AN8C35A	1.000		\$21.85	Lot # 102671 Qty. 1
Subtotal:		QTD:	0	CTD:	1	\$21.85

Date: Wednesday, 08/04/2009 7:50:52 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 32528	Customer	: Dart Helicopters Services					
Estimate Number	: 10266	DWG Name	: 350 SKIDTUBE ASSEMBLY LH					
Purchase Order #	:	Part Number	: D350636013					
Complete Date	: 09/08/2007 12:48:03	DWG Number	: D2750 UNDER REVIEW	Rev.	: D			

34.0 AN960C10L-washer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/08/2007	LAUG01: Laughren, Gary	AN960C10L	46.000		\$1.21	Lot # 105057 Qty. 46	
Subtotal:		QTD:	0	CTD:	46	\$1.21	

35.0 AN960C816L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/08/2007	LAUG01: Laughren, Gary	AN960C816L	2.000		\$0.17	Lot # 104093 Qty. 2	
Subtotal:		QTD:	0	CTD:	2	\$0.17	

36.0 MS210436-NUT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/08/2007	LAUG01: Laughren, Gary	MS210436	4.000		\$7.28	Lot # 103693 Qty. 4	
Subtotal:		QTD:	0	CTD:	4	\$7.28	

37.0 MS21083C8-NUT INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/08/2007	LAUG01: Laughren, Gary	MS21083C8	1.000		\$1.33	Lot # 103492 Qty. 1	
Subtotal:		QTD:	0	CTD:	1	\$1.33	

38.0 NAS1515H3L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/08/2007	LAUG01: Laughren, Gary	NAS1515H3L	46.000		\$4.03	Lot # 104603 Qty. 46	
Subtotal:		QTD:	0	CTD:	46	\$4.03	

39.0 NAS1515H8L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
03/08/2007	LAUG01: Laughren, Gary	NAS1515H8L	10.000		\$10.98	Lot # 104922 Qty. 10	
Subtotal:		QTD:	0	CTD:	10	\$10.98	

40.0 HAND FINISHING1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
03/08/2007	LAUG01: Laughren, Gary	Run	1.000	2.80	\$37.58	2.80	72.91
Subtotal:		QTD:	1	CTD:	0	2.80	\$110.49

43.0 D2741-Blade, 350 Skidtube INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/08/2007	BOUC02: Boucher, Emilie	D2741	1.000		\$85.30	Lot # 30556 Qty. 1	
Subtotal:		QTD:	0	CTD:	1	\$85.30	

44.0 AN960C816L-WASHER INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
07/08/2007	BOUC02: Boucher, Emilie	AN960C816L	2.000		\$0.17	Lot # 104093 Qty. 2	
Subtotal:		QTD:	0	CTD:	2	\$0.17	

Date: Wednesday, 08/04/2009 7:50:52 AM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 32528	Customer	: Dart Helicopters Services
Estimate Number	: 10266	DWG Name	: 350 SKIDTUBE ASSEMBLY LH
Purchase Order #	:	Part Number	: D350636013
Complete Date	: 09/08/2007 12:48:03	DWG Number	: D2750 UNDER REVIEW
		Rev.	: D

45.0 MS21083C8-NUT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
07/08/2007	BOUC02: Boucher, Emilie	MS21083C8	2.000		\$2.66	Lot # 104118 Qty. 2
Subtotal:		QTD: 0 CTD: 2			\$2.66	

46.0 AN8C21A-BOLT INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
07/08/2007	BOUC02: Boucher, Emilie	AN8C21A	2.000		\$25.13	Lot # 104117 Qty. 2
Subtotal:		QTD: 0 CTD: 2			\$25.13	

47.0 NAS1515H8L-WASHER INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
07/08/2007	BOUC02: Boucher, Emilie	NAS1515H8L	2.000		\$2.20	Lot # 104955 Qty. 2
Subtotal:		QTD: 0 CTD: 2			\$2.20	

48.0 D34931-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
07/08/2007	BOUC02: Boucher, Emilie	D34931	2.000		\$12.51	Lot # 32600 Qty. 2
Subtotal:		QTD: 0 CTD: 2			\$12.51	

		TIME	COST	
	Machine Time:	13.63	\$323.27	
	Labor:	13.01	\$203.87	
	Sub-contract (external Op.):		\$0.00	
	INVENTORY ITEM:		\$984.09	
	SUB-COMPONENT (SUB-JOB):		\$0.00	
Total:			\$1511.23	
COST PER UNIT:			\$1511.23	

Scrap Parts:

Part No:	Batch No:	Qty:
D3672-1	B39275	8
AN960C10L	M105057	46
D3536-25	B38565	1
D3794-3	B38361	1
D3794-1	D39279	1
MS21083-C8	M102671	1

#

New Parts:

Part No:	Batch No:	Qty:
D3672-1	B39275	8
AN960C10L	M111279	46
D3536-25	B47011	1
D3794-1	B46530	1
D3794-3	B46531	1
MS21083-C8	M110584	1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
*22	3	3	3	3	3	D3537-1	WEARPAD
*22A	1	1	1	1	1	D3791-1	WEARPLATE (REPLACES D3537-1)
*23A	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*23B	1	1	1	1	1	D3794-1	GASKET (REPLACES D3536-13)
*24A	1	1	1	1	1	D3535-25	WEARSHOE
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*25B	1	1	1	1	1	D3794-3	GASKET (REPLACES D3536-35)
*26A	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	AN960C10L	WASHER
*28	34	34	34	34		ALS4-1032-225	INSERT
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

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Revision: F

Date: 08.08.14